

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024778**Date Inspected:** 03-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW tack welding of temporary alignment beam to deck plate located on PCMK OBG BK12A. Welder was identified as 202319. QC was identified as ZPMC CWI Xu Le Feng (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-P-2112 as verbally identified by QC1.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of temporary alignment plates to deck plates located on PCMK OBG 13BW/13CW at the transverse joint. Welder was identified as 218662. QC was identified as ZPMC CWI Li Peng Fei (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Xiang Pin (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2112-FCM-1 as verbally identified by QCA2.

SMAW repair welding of deck plate base metal located on PCMK OBG 13AW/13BW at the transverse joint. Welders were identified as 066398, 201215. QC was identified as QC2. Assisting QC2 at this location and

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appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-345-SMAW-1G(1F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-CWR2861 as presented to this QA Inspector and verbally identified by QCA2.

SMAW welding of weld joint SEG3007AH-062 located on PCMK OBG 13AE. Welders were identified as 066476, 068859. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA3), who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1 as verbally identified by QCA3.

FCAW welding of weld joint SEG3007V-034 located on PCMK OBG 13BE. Welder was identified as 055564. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3007V-037 located on PCMK OBG 13BE. Welder was identified as 052696. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QCA3.

SMAW welding of weld joint SEG3013-075 located on PCMK OBG 13BE. Welder was identified as 021553. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA3.

SMAW welding of weld joints SEG3019G-009, 011 located on PCMK OBG 14E. Welder was identified as 216086. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2213-FCM-1 as verbally identified by QCA3.

SMAW welding of weld joints SEG3019G-018, 096 located on PCMK OBG 14E. Welder was identified as 216086. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA3.

SMAW repair welding of various weld joints located on PCMK OBG 14E, edge plate at panel point 127.3. Welder was identified as 501946. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-345-SMAW-1G(1F)-FCM-repair-1 as verbally identified by QCA3. QCA3 informed this QA Inspector that the repairs were the result of indications observed during visual inspection (VT) performed by ZPMC and ABF personnel.

SMAW welding of weld joint SEG3013P-072 located on PCMK OBG 13AW. Welder was identified as 066674. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation

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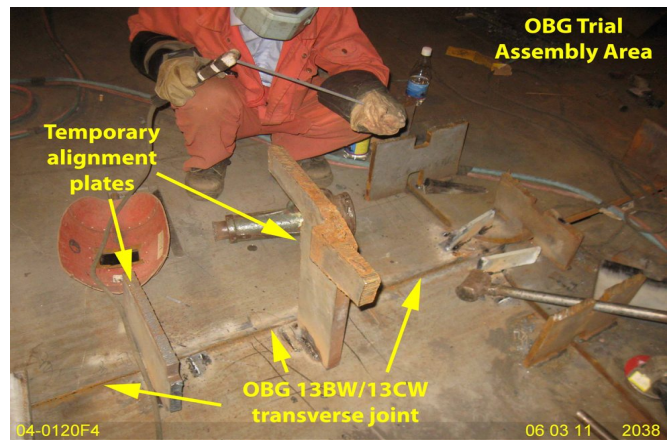
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and recording data was ZPMC QC Zhang Lin (QCA4), who was not a CWI. Weld variables recorded by QCA4 appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1 as verbally identified by QCA4.

SMAW welding of weld joint3 SEG3013P-074, 075, 076 located on PCMK OBG 13AW. Welder was identified as 066673. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA4, who was not a CWI. Weld variables recorded by QCA4 appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1 as verbally identified by QCA4.

SMAW welding of weld joint3 AH3003-024~027 located on PCMK OBG 13CW. Welders were identified as 070009, 069866. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA4, who was not a CWI. Weld variables recorded by QCA4 appeared to comply with WPS-B-P-2114 as verbally identified by QCA4.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
